

Work Order ID 85305

85305

Page 1

June-05-12 3:33:09 PM

Item ID: D3700-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Outboard Window Doubler

Start Date: 05/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3700	Rev B
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100		0.00
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100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3700 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

6061 .050"

2 0 Jun 12-6-15

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC

Memo

0.00

Quality Control

2 0 Jun 12-6-15

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------

120

QC

Memo

0.00

Quality Control

5/26/15

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

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Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>136</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

AB 12 - 6 - 17 (2)

(Signature) (2)

(Signature) (2)

W/O:		WORK ORDER CHANGES					
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Required Date: 19/06/2012 Req'd Qty: 2.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____
QC: _____ Date: _____ SPC (Y/N): _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/6/18 *[Signature]*

mf
12 06-18

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-05-12 3:33:17 PM

Page 1

Work Order ID: 85305

85305

Parent Item: D3700-3

D3700-3

Parent Item Name: Outboard Window Doubler

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.050		Purchased	No				sf	194.4640					
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M6061T6S 050

6061-T6 .050 Sheet

**

5.62

Jim
12-6-15

Location

Loc Qty

Loc Code

021

118.3

1211920

118.3

MAT021

76.164

114799

61.164

114993

15

114799

W/O:		WORK ORDER CHANGES					
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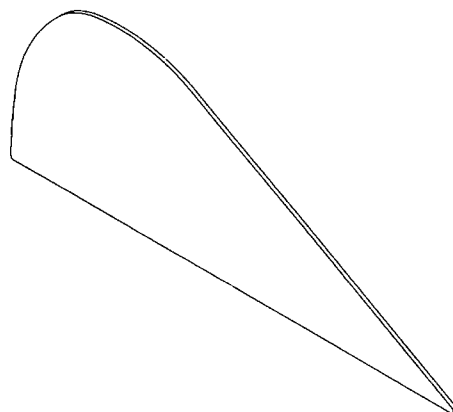
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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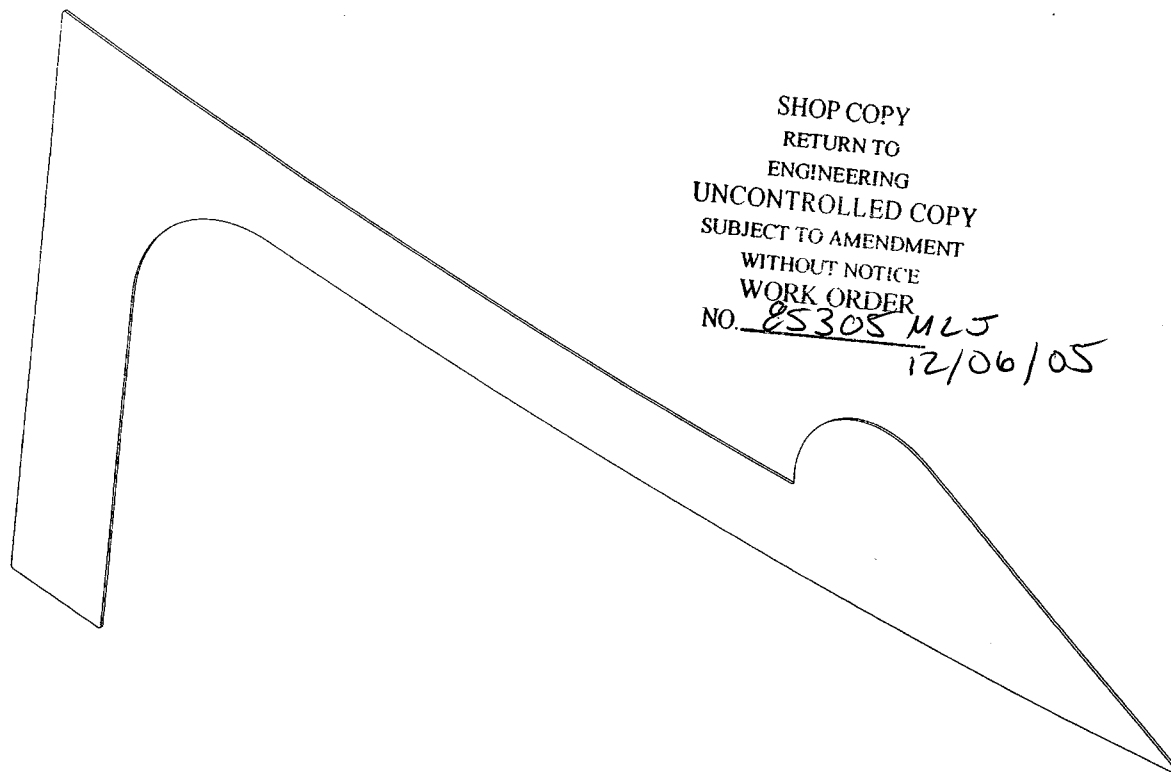
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D3700-1 INBOARD WINDOW DOUBLER



D3700-3 OUTBOARD WINDOW DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85305 MLJ
12/06/05

RELEASED
09/21/18

B	ADDED 0.25" TO TOP PROFILE OF D3700-1 (ZN D8-2). REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).	MB	09.03.18
A	NEW ISSUE	MB	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3700	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		WINDOW DOUBLER	NTS
DE APPR.		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DATE	09.03.18		

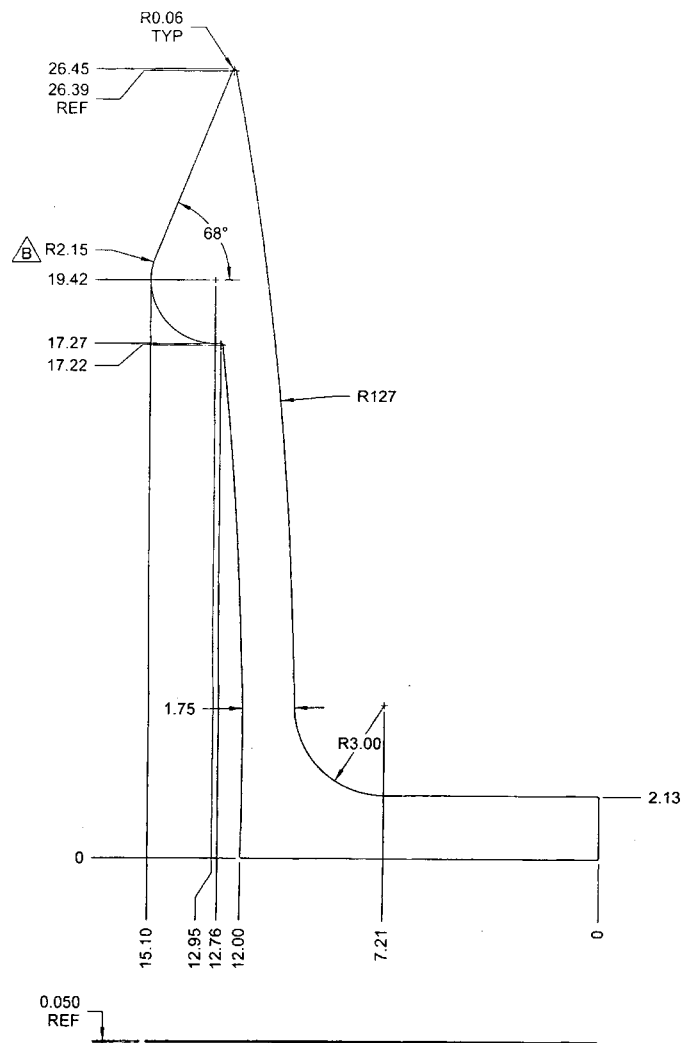
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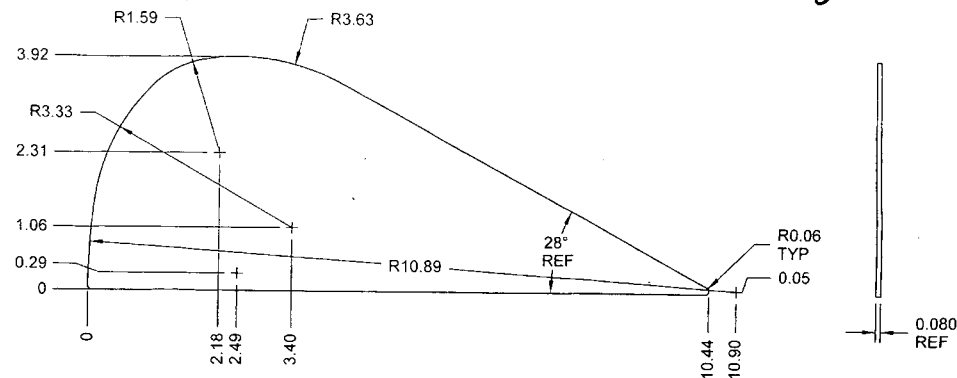
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D3700-3 OUTBOARD WINDOW DOUBLER



D3700-1 INBOARD WINDOW DOUBLER

RELEASED
9/14/09

NOTES:

- 1) MATERIAL:
D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3700-1 = 0.20 lbs
D3700-3 = 0.37 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	NTS
DATE	09.03.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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